

Work Order ID 130702

Monday, March 23, 2015 10:13:21 AM

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Item ID: D2938-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle RH Out, 206
 Start Date: 3/23/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 3/23/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 150323 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00
 100 HAAS 1 Memo 0.07
 HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per
 4 0 JFC 2015-3-27

110 CONVENTIONAL MILLING MACHINE 0.00
 110 Mill Conv Memo 0.00
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet
 4 0 JFC 2015-03-27

120 QC1- Inspection performed by CMM 0.00
 120 QC Memo 0.00
 Quality Control
 4 0 JFC 2015-03-27

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 Required Date: 3/23/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						4	Ø		DAS 44 9-89 15/03/28
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						4	Ø	15-3-30	
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150						4	Ø	15-3-31	DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 11:35								
	FINISH TIME: 12:05								

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Required Date: 3/23/2015 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00				(4)			DAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									MAR 31 2015
170	Identify as per dwg & Stock Location: <u>st 395</u>	0.00				y			DAS 27 9-89
170									
Packaging	Memo	0.00							
Packaging									MAR 31 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									MAR 31 2015

MS-4-1

Picklist Print

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Parent Item: D2938-2

D2938-2

Parent Item Name: Saddle RH Out, 206

Start Date: 3/23/2015

Required Date: 3/23/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	20.0000	1	4			

D6101-003

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT040

4

115091

4

MAT044

15

120394

13

128906

2

MAT045

1

114314

1

4

OK
2015-03-26

DART AEROSPACE LTD		Work Order: 130702
Description: 206 Saddle, Outboard, Right side		Part Number: D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.132	0.130	0.131	0.133		
B	0.100	0.140		0.132	0.130	0.131	0.128		
C	0.100	0.140		0.113	0.116	0.111	0.113		
D	0.210	0.230		0.223	0.223	0.223	0.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.127	0.125	0.126	0.125		
O	0.540	0.560		0.550	0.550	0.550	0.550		
P	0.490	0.510		0.496	0.500	0.498	0.495		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.253	0.251	0.250	0.252		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.250	1.270		1.2624	1.2624	1.263	1.2620		
Y	1.565	1.585		1.5742	1.5751	1.5777	1.5744		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JFC
Date:	2015-03-27

Audited by:	FK
Date:	15/03/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

